

Date: Thursday, 10/25/2007 10:05:46 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GPS RECEIVER HOUSING
Job Number	: 35359		
Estimate Number	: 12887		
P.O. Number	: <i>N/A</i>	Part Number	: D3514043
This Issue	: 10/25/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3514 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 34784	Material	: <i>N/A</i>
Written By	:	Due Date	: 11/8/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	4 Um: Each
Comment	: Est Rev: A New Issue 07-09-24 EC verified by DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3514047	TOP MOUNTED HOUSING ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
TOP MOUNTED HOUSING ASSEMBLY  
Batch: *B35369*

*mf*

2.0	D35221	GASKET
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
GASKET  
Batch: *B34801 x 2mx, B35370 x 2mx*

*mf*

3.0	D35233	LEG
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
LEG  
Batch: *B35468 ① B35752 ③*

*mf*

4.0	D35241	LOWER PLATE
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
LOWER PLATE  
Batch: *B34803*

*mf*

5.0	D3531041	BRACKET ASSEMBLY
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BRACKET ASSEMBLY  
Batch: *B35371*

*mf 07-12-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:05:46 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 35359

Part Number: D3514043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35333

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Set Screw

Batch: B34899

mf

7.0

AN36A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: m100184

mf

8.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: m104374

mf

9.0

MS24693S29

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Screw

Batch: m103915

mf 07-12-21

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3514

mf 07-12-21

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 02/12/21 (x4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

SS 02/12/21 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/12/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:05:46 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 35359

Part Number: D3514043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

207/12/04

Job Completion



U 07.1224

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

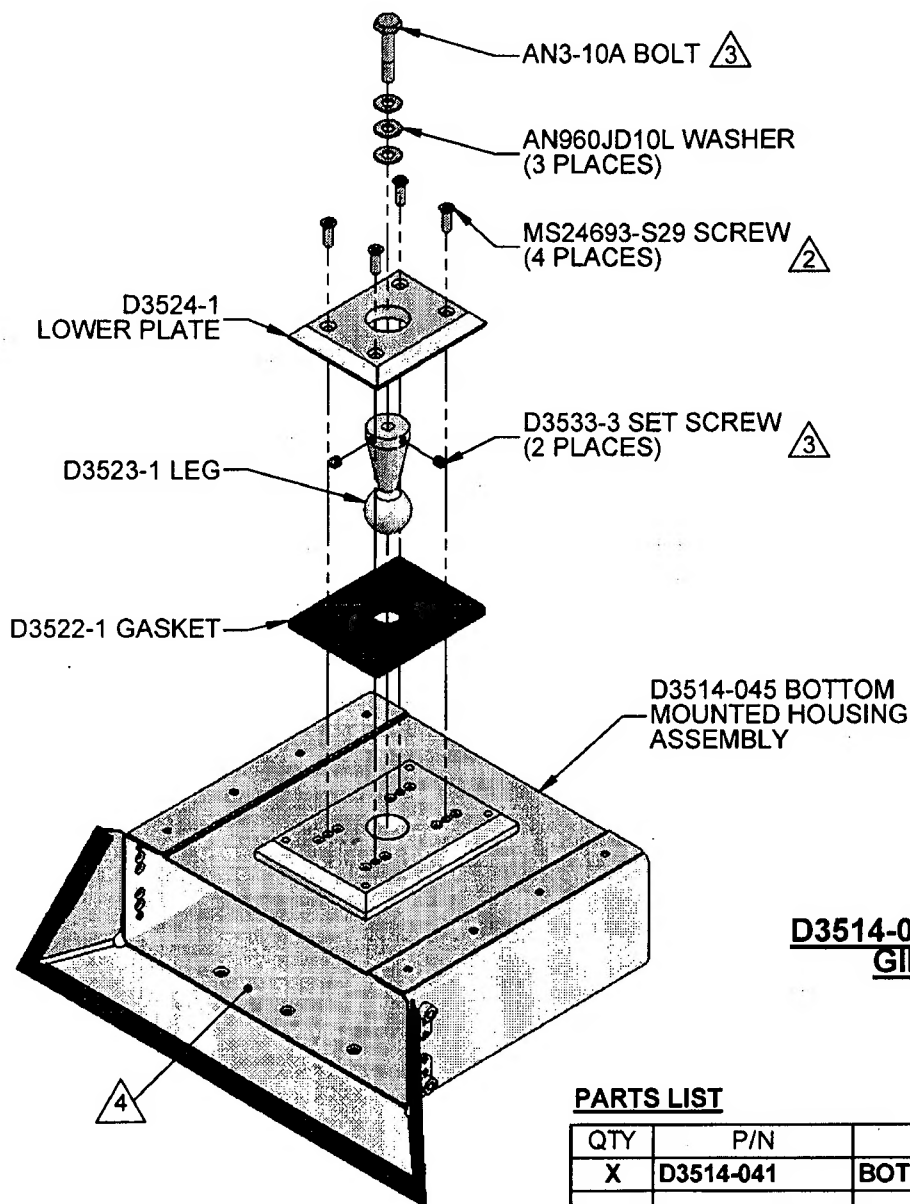
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	
REV A		DATE 07.06.18	SCALE 1:3
		DESCRIPTION NEW ISSUE	



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07.08.07

**D3514-041 BOTTOM MOUNTED  
GIMBAL ASSEMBLY**

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35359

**PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

**NOTE:**

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

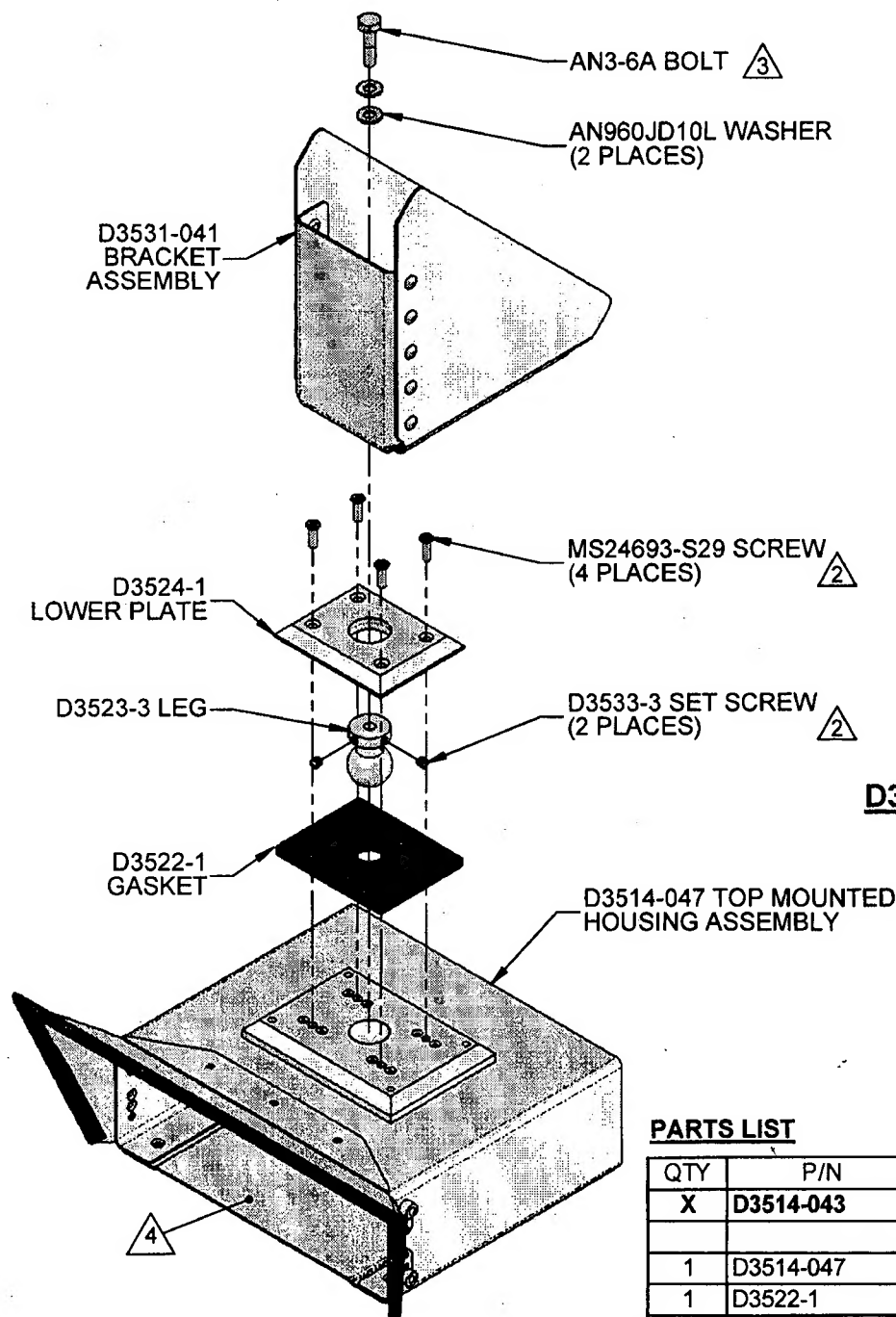
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DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 2 OF 9 SCALE 1:3

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07.08.03



**D3514-043 TOP MOUNTED GIMBAL ASSEMBLY**

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WITHOUT NOTICE  
WORK ORDER  
NO **35359**

**NOTE:**

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

**PARTS LIST**

QTY	P/N	DESCRIPTION
<b>X</b>	<b>D3514-043</b>	<b>TOP MOUNTED GIMBAL ASSEMBLY</b>
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

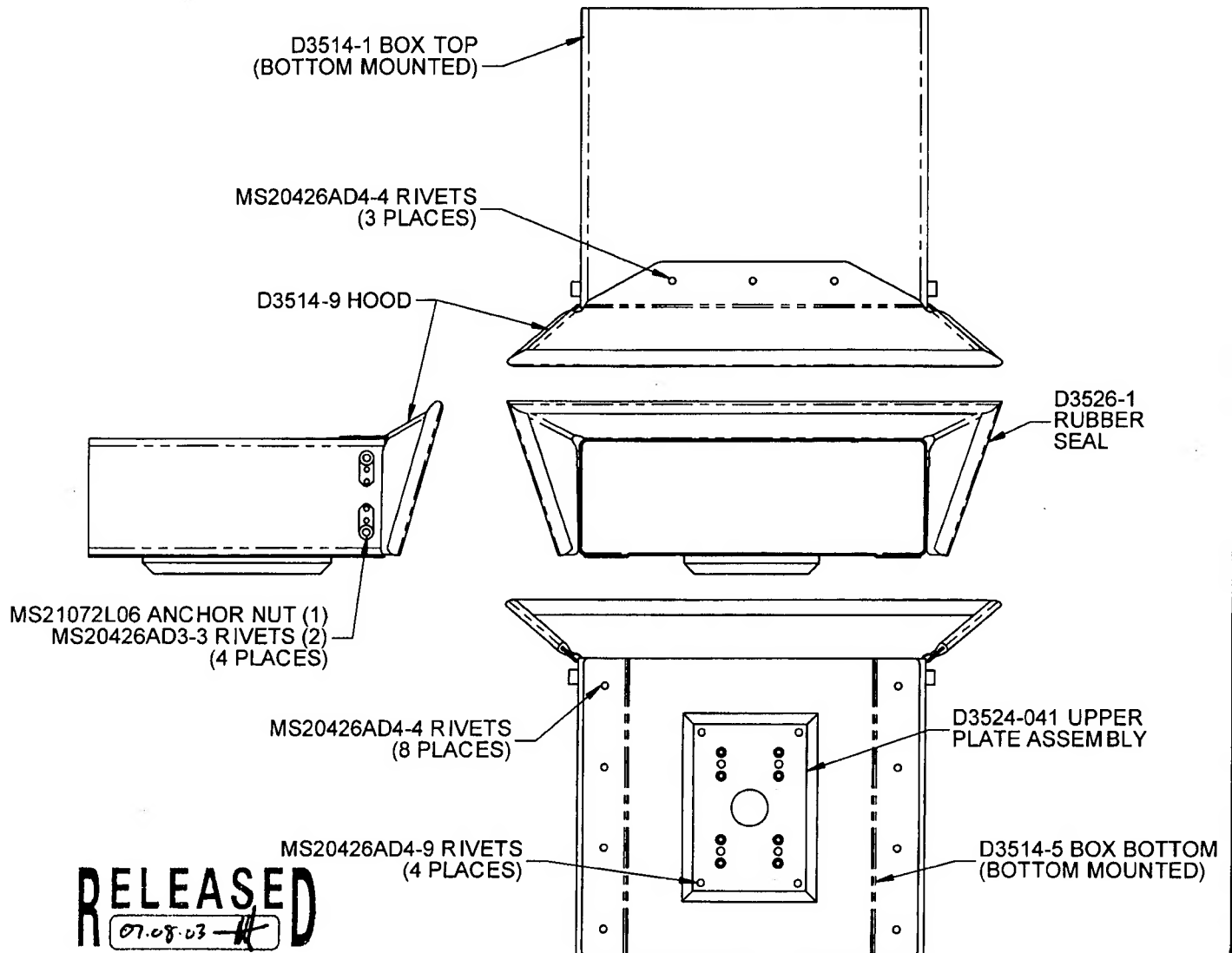
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3



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07.08.03 *[Signature]*

**D3514-045 BOTTOM MOUNTED  
HOUSING ASSEMBLY**

**NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

**PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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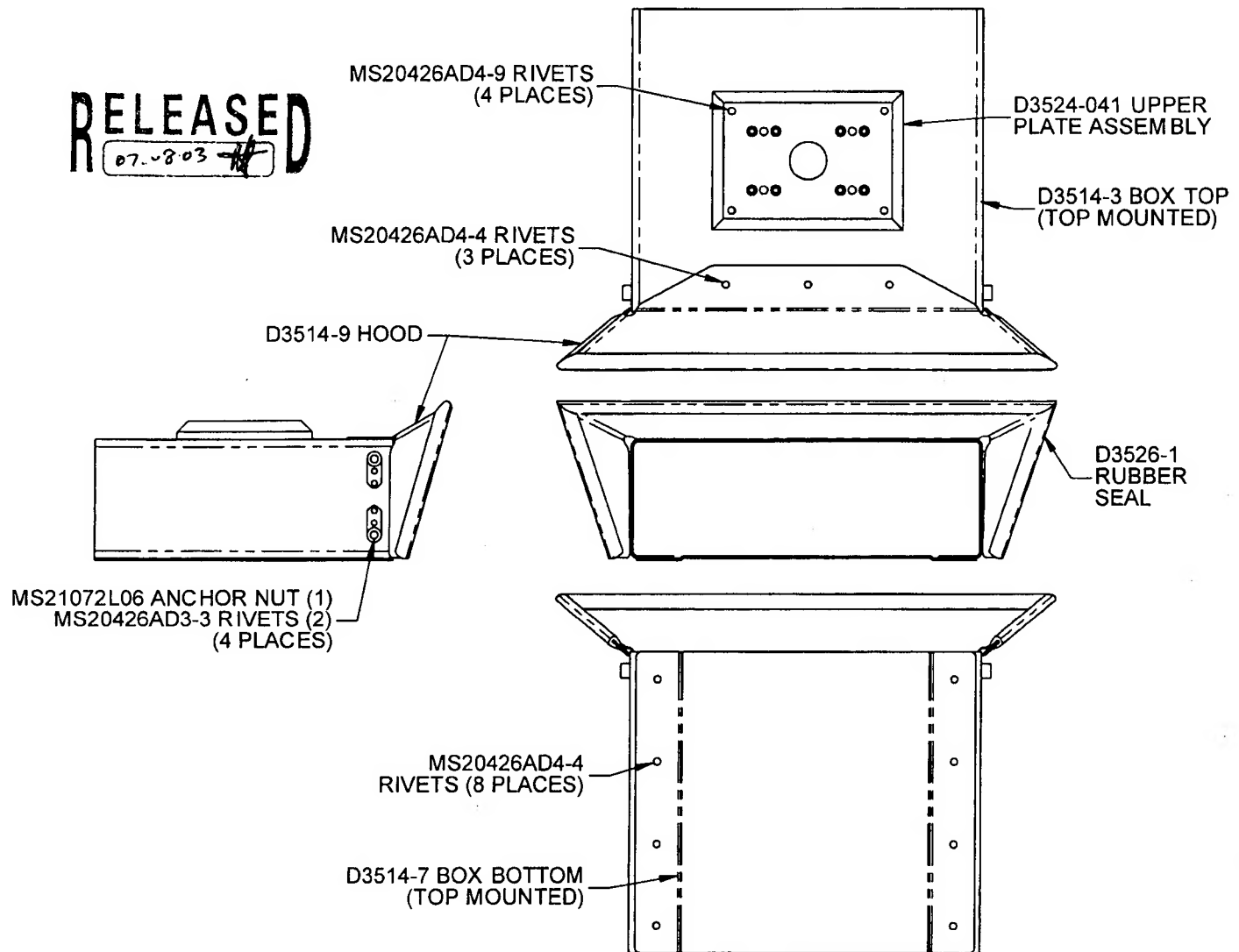
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DATE <b>07.06.18</b>		TITLE <b>GPS RECEIVER HOUSING</b>	SCALE 1:3

**RELEASED**  
07-08-03



**D3514-047 TOP MOUNTED  
HOUSING ASSEMBLY**

**NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

**PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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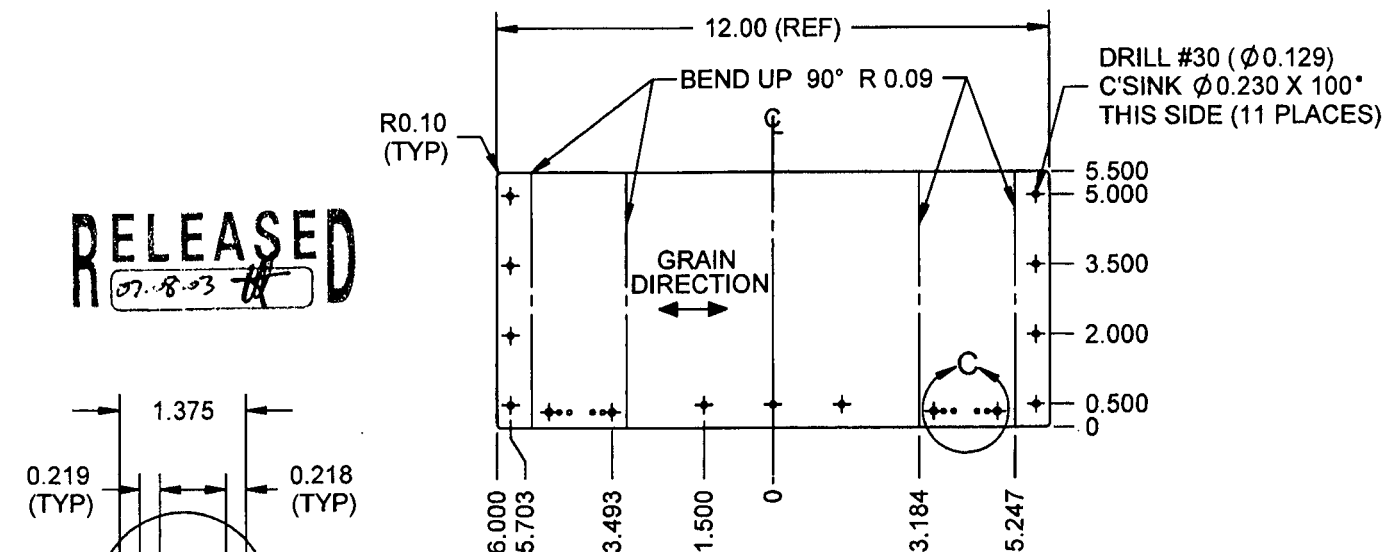
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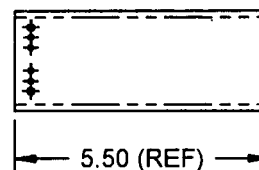
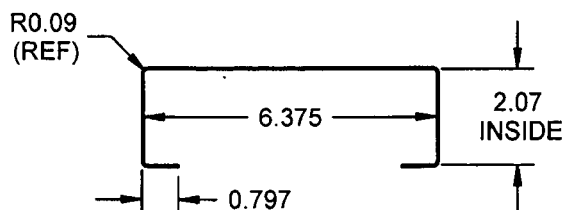
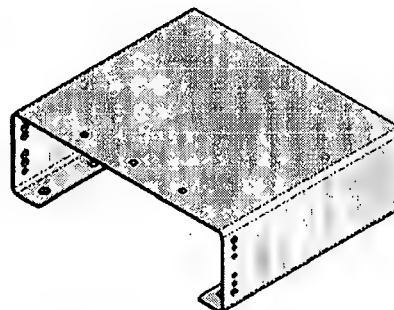


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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:4

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07.08.03



**D3514-1F  
FLAT PATTERN**



**D3514-1 BOX TOP (BOTTOM MOUNTED)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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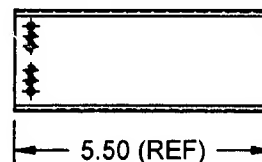
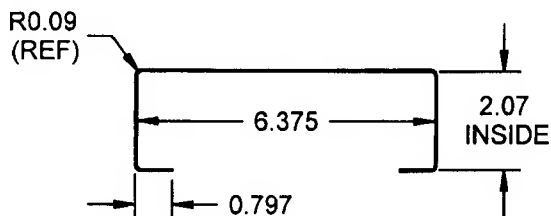
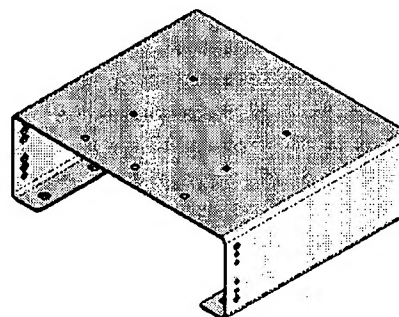
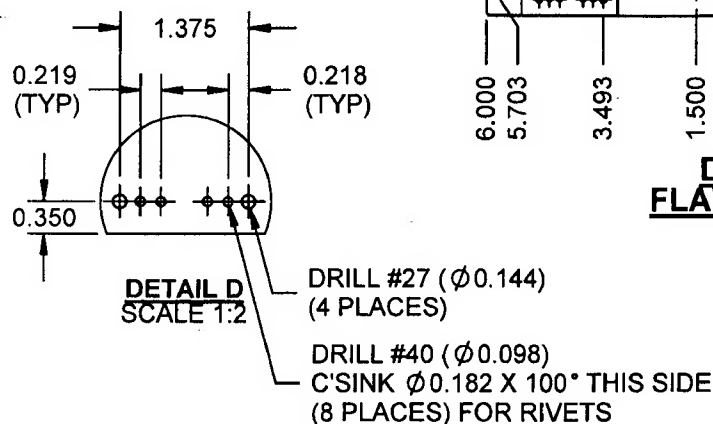
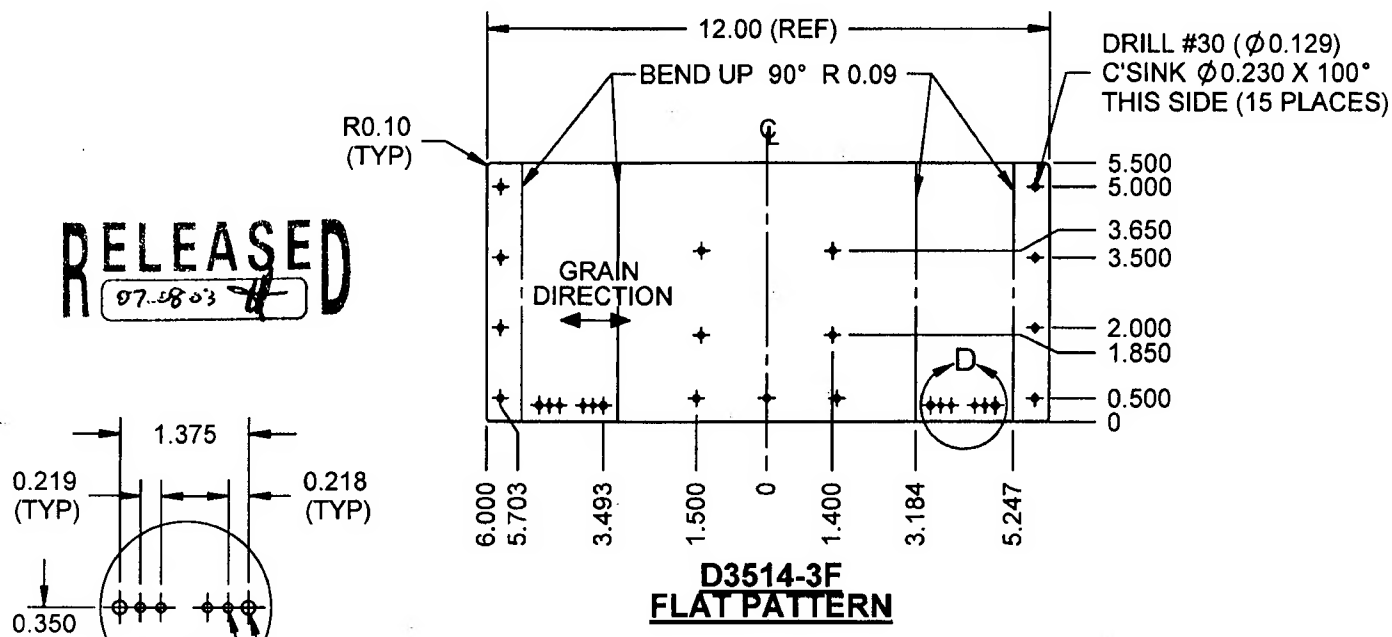
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DATE <b>07.06.18</b>		TITLE <b>GPS RECEIVER HOUSING</b>	SCALE 1:4

**RELEASED**  
07.08.03



### **D3514-3 BOX TOP (TOP MOUNTED)**

#### **NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

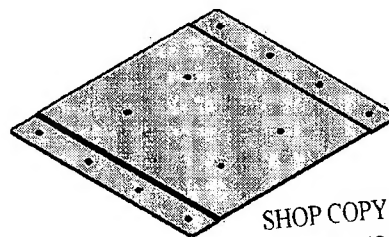
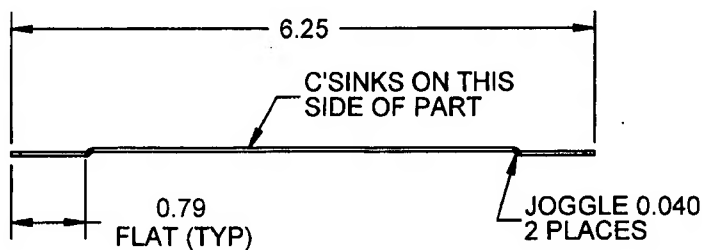
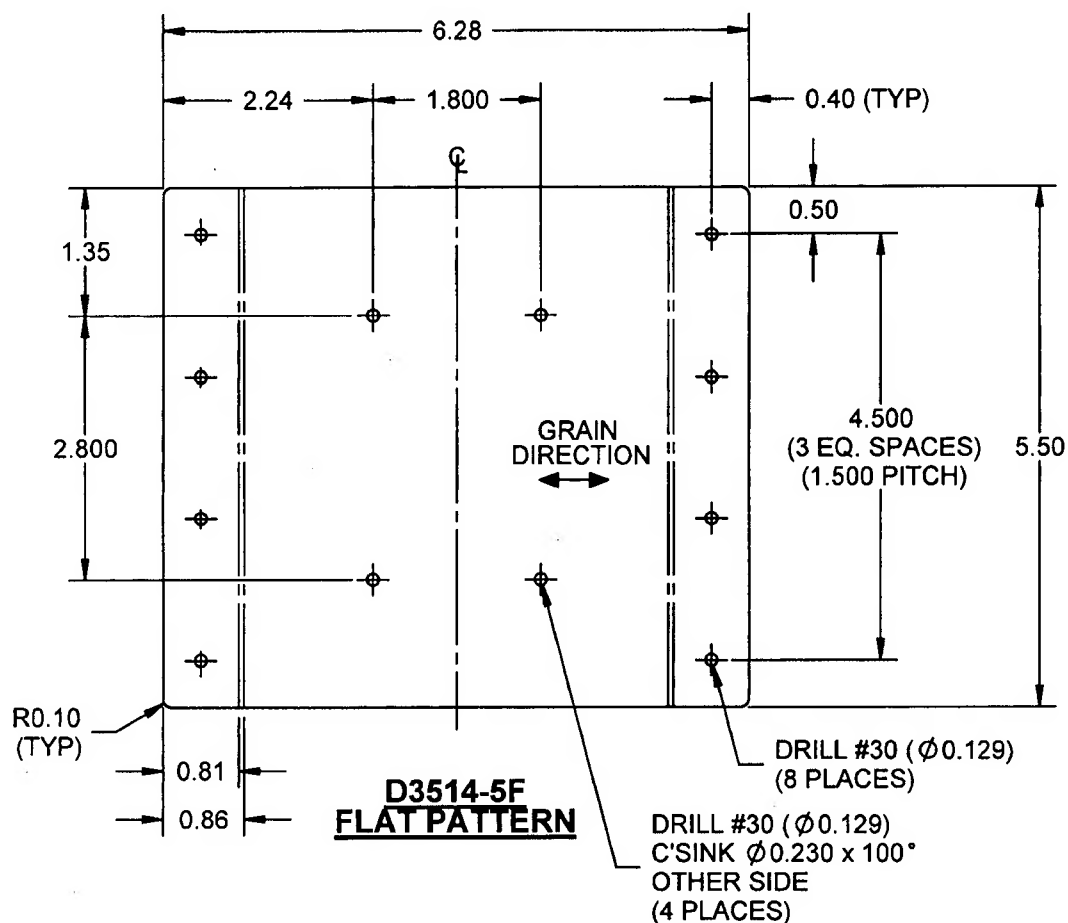
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DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 7 OF 9 SCALE 1:2



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**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$
- 7) C'SINK ABOVE JOGGLE

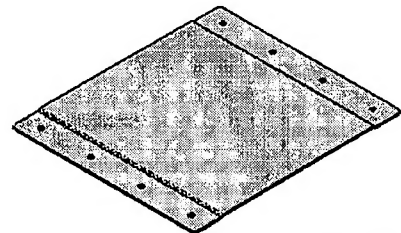
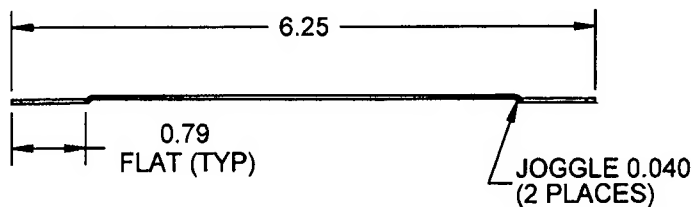
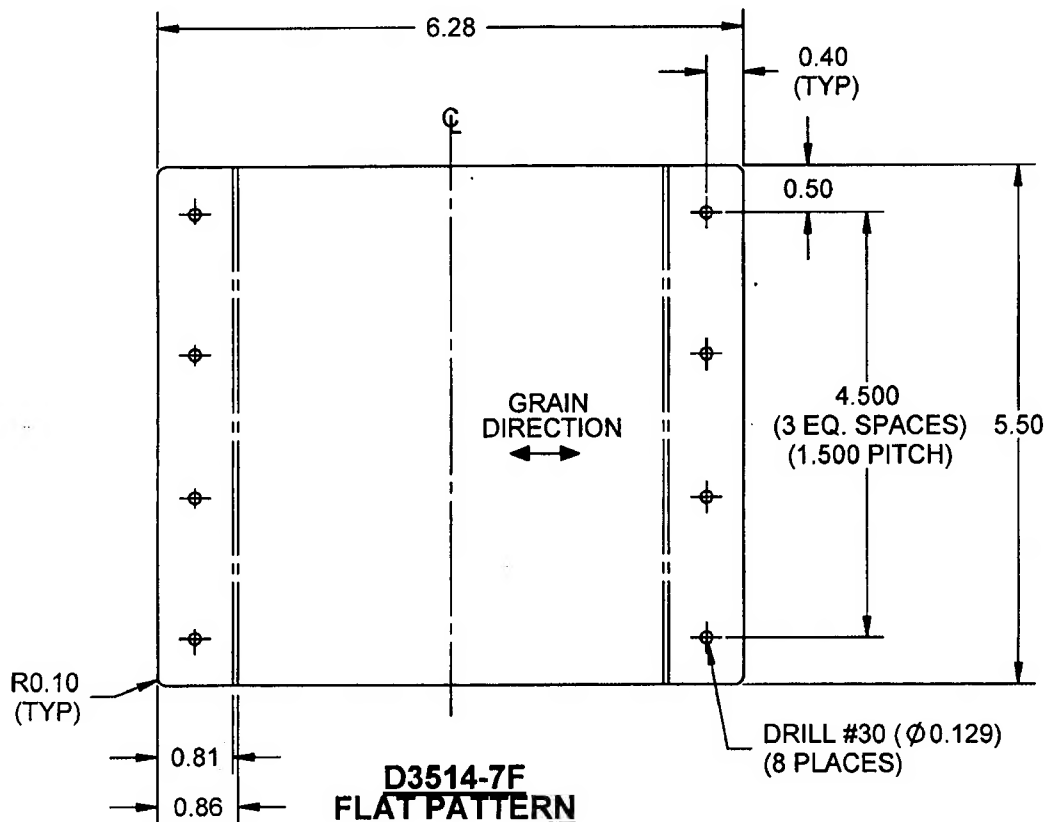
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DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 8 OF 9 SCALE 1:2



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NO. **35359**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

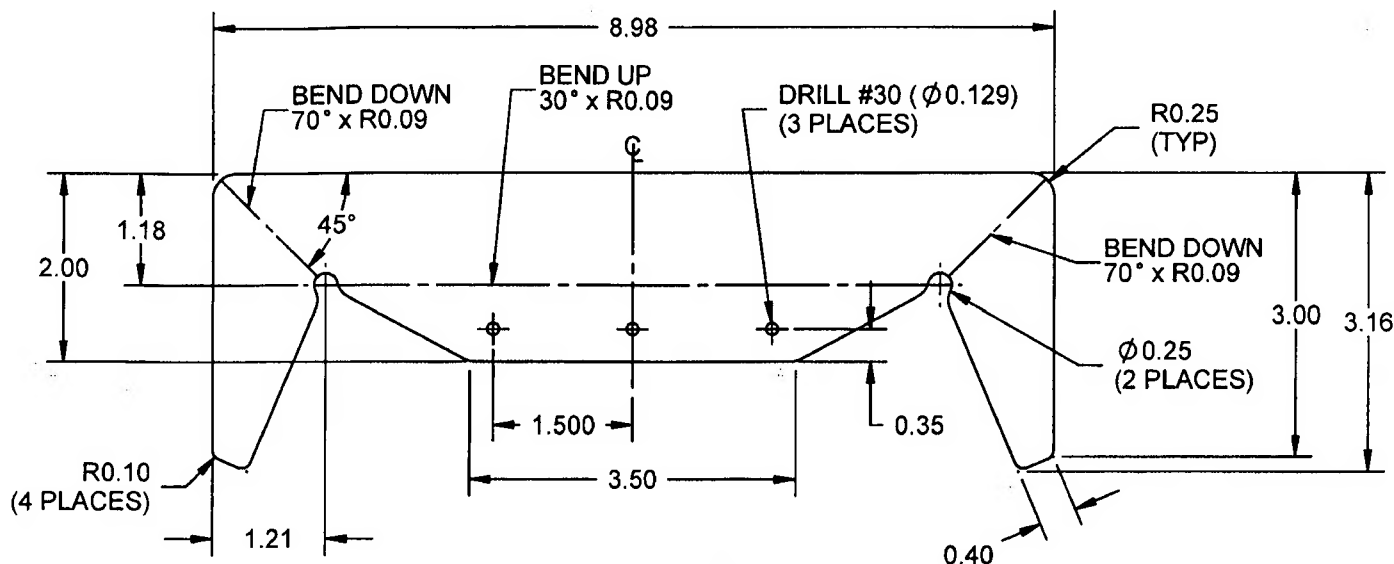
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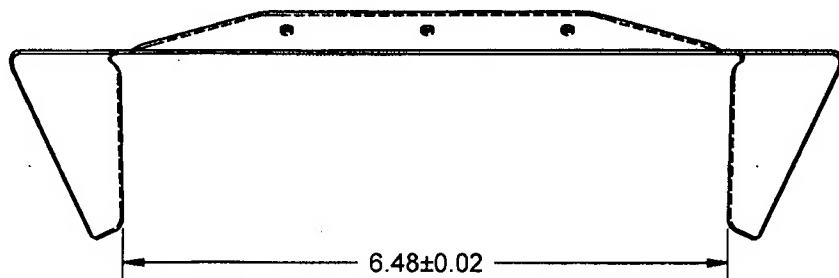
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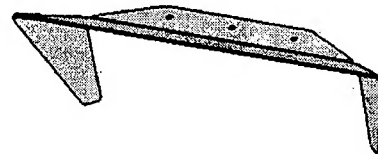
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DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 9 OF 9 SCALE 1:2



**D3514-9F**  
**FLAT PATTERN**



**FRONT VIEW**



**D3514-9 HOOD**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\bar{C}$

**RELEASED**

07.08.03

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